

Date: Monday, 16/06/2008 10:25:34 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FOOT
Job Number :	39892		
Estimate Number :	11245		
P.O. Number :		Part Number :	D34371
This Issue :	16/06/2008 S.O. No. :	Drawing Number :	D3437 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ / Type : MACHINED PARTS	Drawing Revision :	B
Previous Run :	36538	Material :	
Written By :		Due Date :	30/06/2008 Qty: 10 Um: Each
Checked & Approved By :	<u>JUL 08 6.16</u>		
Comment :	Est. A 05.05.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.5424 f(s)/Unit Total : 5.4243 f(s)
 ROUND BAR 1.00"

Material : 6061-T6 Round Bar Ø1.00" (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R1.000)

Identify for D3437-1 M101417

Batch: ~~M101417~~

Dwg Rev. B

MME 08/06/21

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut Blanks 6.125" long

MME 08/06/21

(16)

3.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE
 turn as per D3437

MME 08/06/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MME 08/06/21

(16)

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Mill as per Dwg D3437

MME 08/06/21

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/06/2008 10:25:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOOT

Job Number: 39892

Part Number: D34371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask threaded hole

START TIME:

8:06

OVEN TEMPERATURE:

320

FINISH TIME:

8:30

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

97 92

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

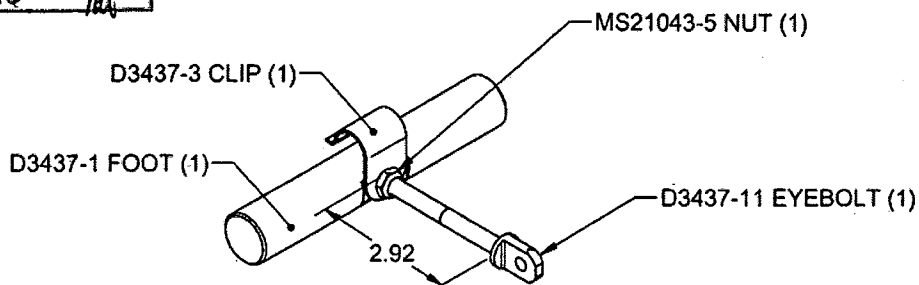
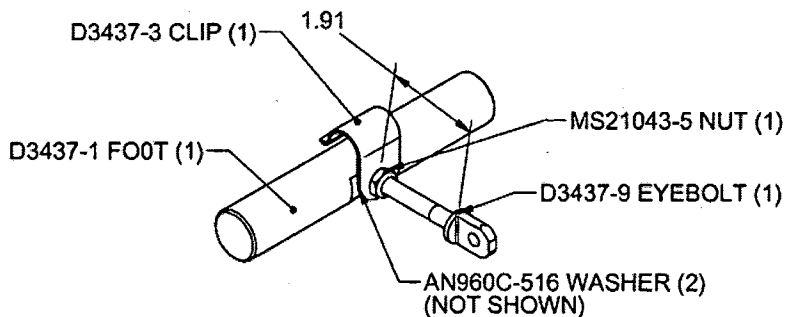
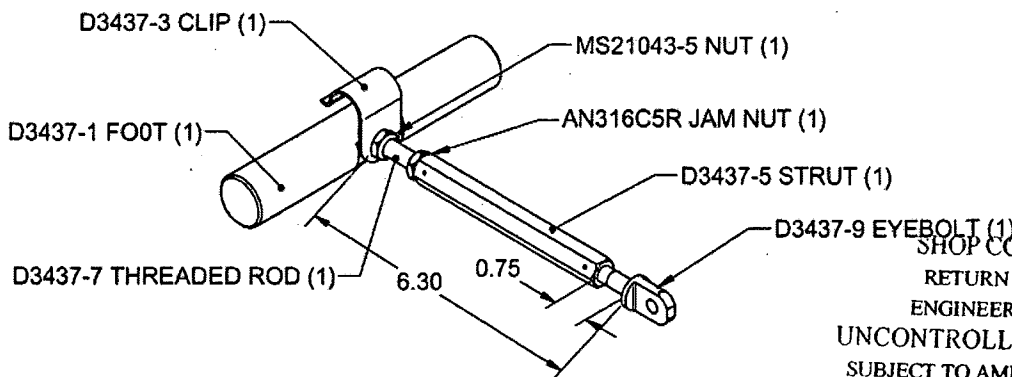
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

RELEASED05.08.16 *[Signature]***D3437-041 AFT STRUT ASSEMBLY****D3437-043 AFT STRUT ASSEMBLY****D3437-045 AFT STRUT ASSEMBLY**

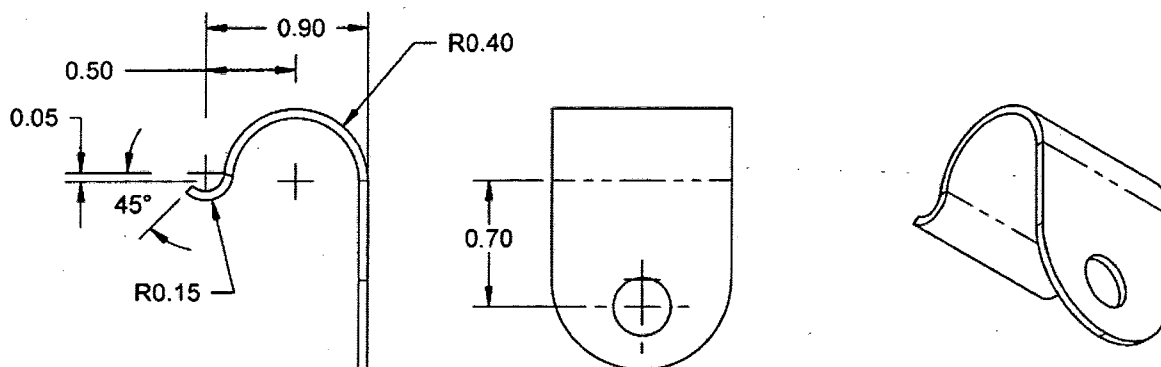
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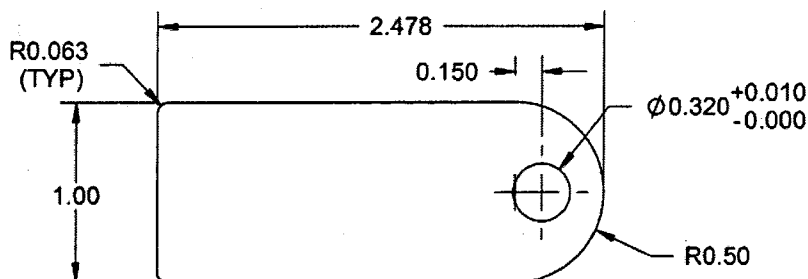
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED05.08.16 *[Signature]*

D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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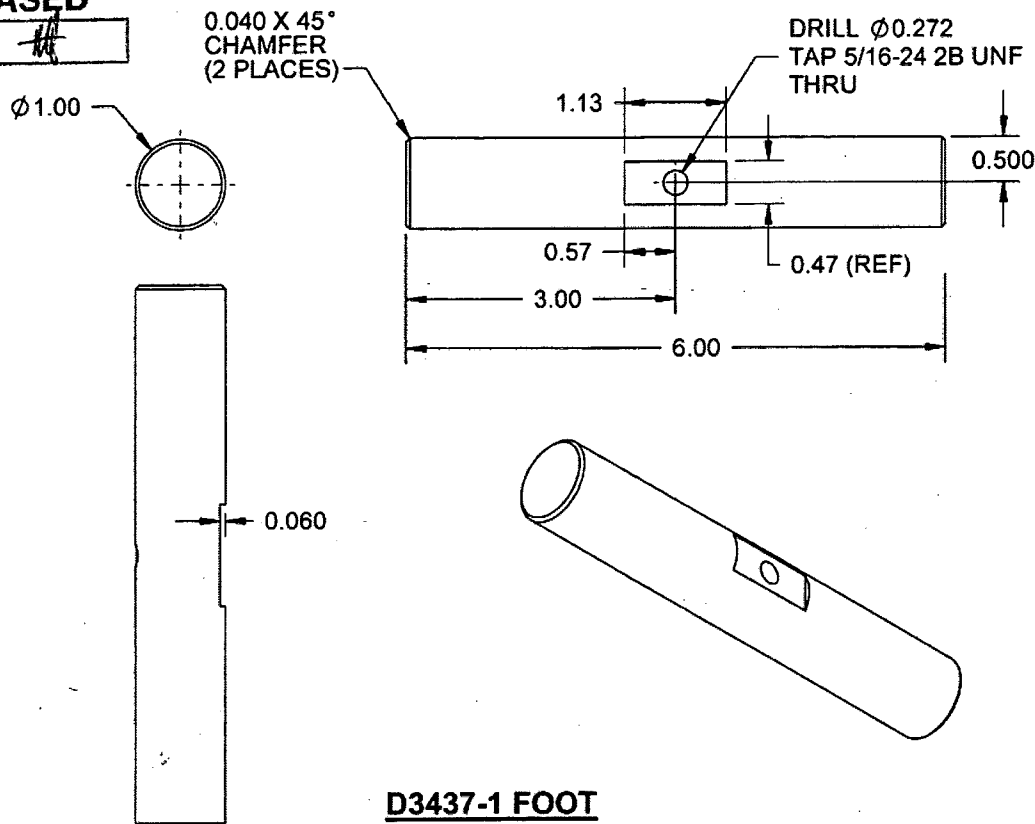
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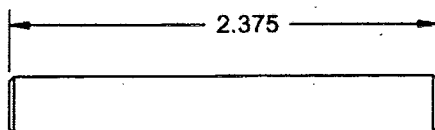
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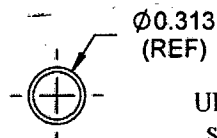
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DATE 05.08.11		TITLE AFT STRUT ASSEMBLY	SCALE 1:2

RELEASED05-08-16 *[Signature]***D3437-1 FOOT****D3437-1 FOOT:**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**D3437-7 THREADED ROD****D3437-7 THREADED ROD:**

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAU P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



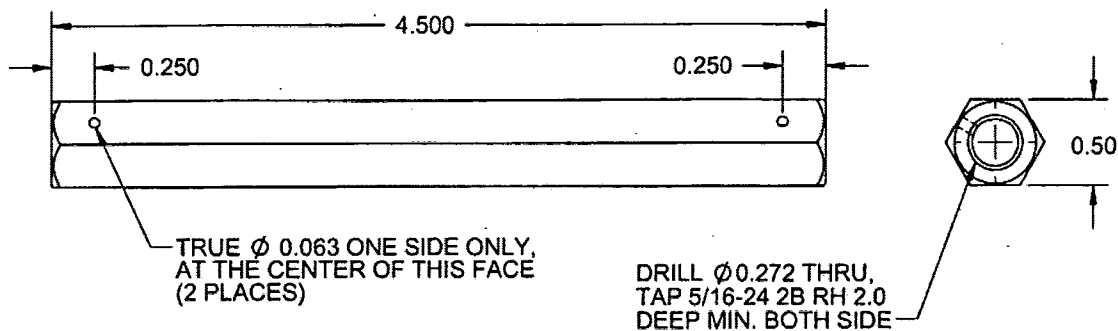
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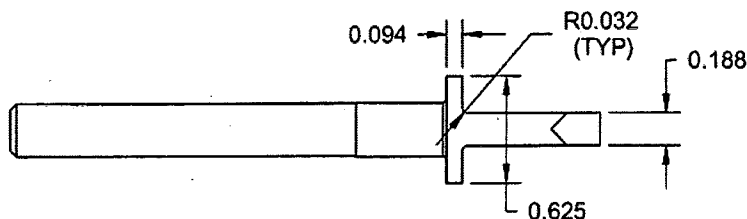
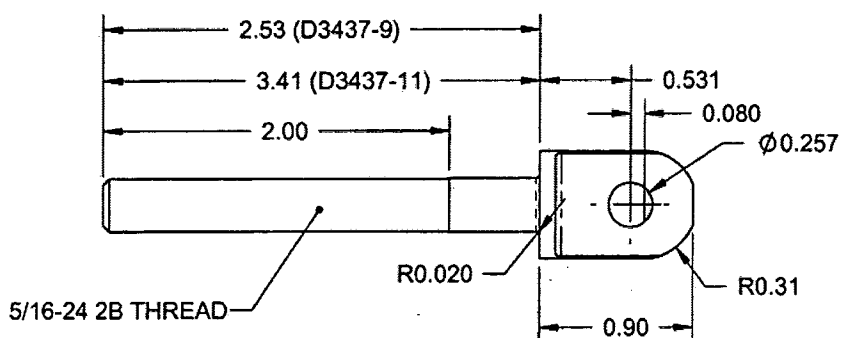
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DATE 05.08.11	TITLE AFT STRUT ASSEMBLY		SCALE 1:2

**D3437-5 STRUT:**

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**05-08-16 *[Signature]***D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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